Work Order ID 98367

March-12-13 1:48:42 PM

98367

Item ID:	D3929-042	Accept	***N900040100***	Setup Start	***NS1***
Revision ID:				Stop	***NS2***
Item Name:	Gusset Assembly				
Start Date:	3/15/13	**Start Qty:** 6.00	*6*	**Cust Item ID:**	
Required Date:	3/22/13	**Req'd Qty:** 6.00	*6*	**Customer:**	
Reference:					

		Run Start	***NR1***
Approvals: Process Plan: ML J Date: 13-03-14	Tooling: _____ Date: _____		
QC: _____ Date: _____	SPC (Y/N): _____ Date: _____	Stop	***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								
100		0.00							
100 Waterjet FLOW CNC Waterjet 304 .125	Memo 1-Cut as per Dwg D3929 Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00				12	0		Ae 13·11·04
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC Quality Control	Memo	0.00				12	0		Ae 13·11·04

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Item ID:	D3929-042		Accept	*N9000401000*	Setup	Start	*NS1*
Revision ID:							
Item Name:	Gusset Assembly					Stop	*NS2*
Start Date:	3/15/13	Start Qty: 6.00	*6*				
Required Date:	3/22/13	Req'd Qty: 6.00	*6*	Cust Item ID:			
Reference:				Customer:			

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120			DAS 27 9-89			12			
QC	Memo	0.00							
Quality Control		*13 11.04*							
140		0.00							
140						*12*		*772*	*13·11·27*
Large Fab	Memo	0.00							
Large Fab	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch: *M125054*								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
150						*12*	*13-11-28*		
QC	Memo	0.00							
Quality Control									

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: _____	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Part No. _____	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Item ID:	D3929-042	Accept	*N900040100*
Revision ID:			
Item Name:	Gusset Assembly		

Setup Start *NS1*

Stop *NS2*

Start Date:	3/15/13	**Start Qty:** 6.00	*6*	**Cust Item ID:**
Required Date:	3/22/13	**Req'd Qty:** 6.00	*6*	**Customer:**
Reference:				

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: _____   Date: _____   Tooling: _____   Date: _____

QC: _____   Date: _____   SPC (Y/N): _____   Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				(12)	13-11-25		DAS 9 9-89
	Memo	0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00				12x	DAS 43 9-89	13-11-28	
	Memo	0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					13/11/29		
	Memo	0.00					mf 13-11-28		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print
March-12-13 1:48:42 PM

Work Order ID:	98367								
Parent Item:	D3929-042				Start Date: 3/15/13		Required Date: 3/22/13		
Parent Item Name:	Gusset Assembly				Start Qty: 6.00		Required Qty: 6.00		

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	258.0000	0.45	2.8421052			

Location	Loc Qty	Loc Code
MAT020	258	
122521	66	
24445	192	

Au 13·11·04

126075 → 5,7

| D3907-1 Bushing | | Manufactured | No | | | 130 | Each | 92.0000 | | 2 | | | |

(24) ⅹ₂ me 13·11·27

Location	Loc Qty	Loc Code
WA004	52	
88891	1	
89688	1	
95215	15	
96302	35	
WA007	40	
96746	40	

B 106314 × 24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear		General				
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced		
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure		
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld		
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled		
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved			
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong			
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other		
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	_____			
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____			
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____			
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions				

DART AEROSPACE LTD		Work Order:	*98367*
Description: Support Gusset		**Part Number:**	D3929-1
Inspection Dwg: D3929 **Rev:** A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	.377	—		V	Jкم~07
0.500	+/-0.010	.500	—		V	
0.500	+/-0.010	.500	—		V	
4.036	+/-0.010	4.036	—		V	
4.382	+/-0.010	4.382	—		V	
8.274	+/-0.010	8.274	—		T	
10.915	+/-0.010	10.915	—		T	
1.000	+/-0.010	1.000	—		V	
11.198	+/-0.010	11.198	—		T	
0.500	+/-0.010	.500	—		V	
1.572	+/-0.010	1.572	—		V	
0.125	+/-0.010	.116	—		V	

Measured by: _Ak_	Audited by: ~~DAS~~ 27 ~~9-80~~	Prototype Approval:	N/A
Date: 13·11·04	Date: 13 11 04	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.05.27	New Issue P/O D3929-041/-042		KJ	

H:\FORMS\Quality Assurance\approved QA\FAI revD

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET
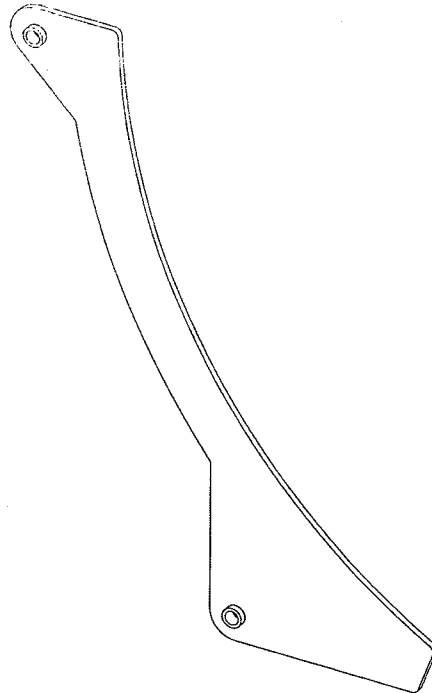
D3929-041 GUSSET ASSEMBLY
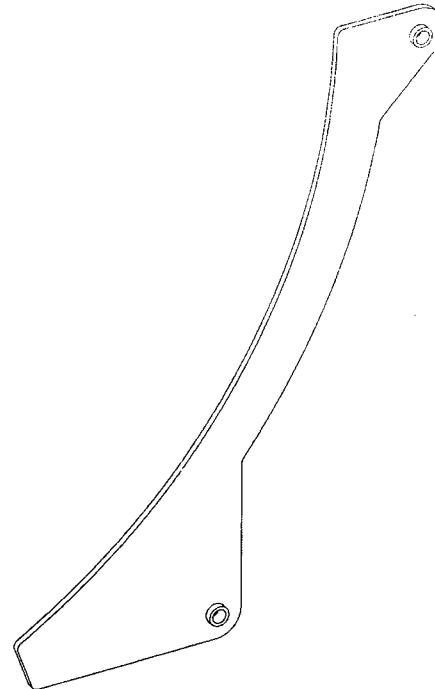
D3929-042 GUSSET ASSEMBLY
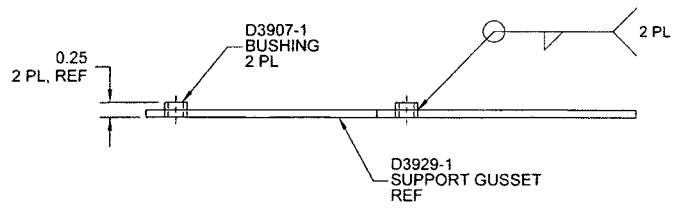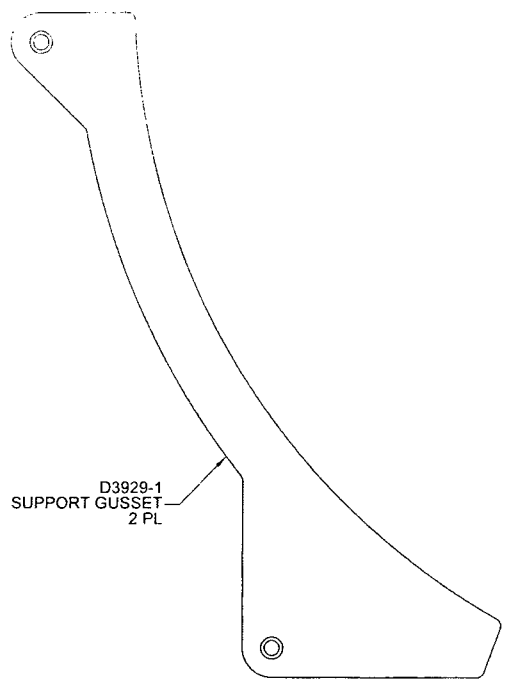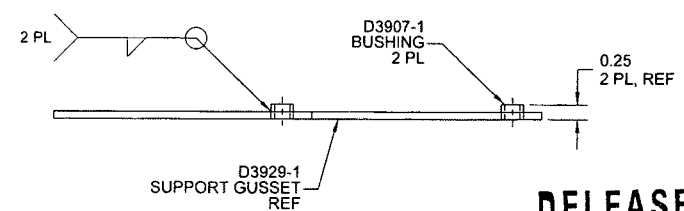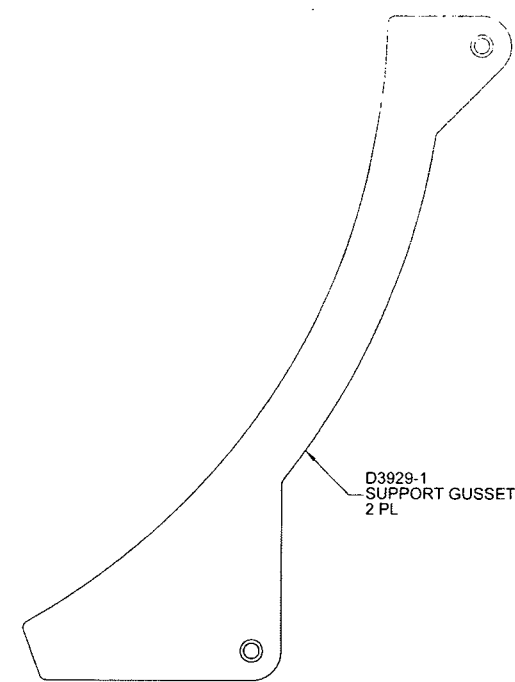
RELEASED

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

A	NEW ISSUE			MB	09.04.03
REV.		DESCRIPTION		BY	DATE

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3929 SHEET 1 OF 3
APPROVED		TITLE SCALE
DE APPR.		GUSSET ASSEMBLY NTS
DATE 09.04.03		COPYRIGHT © 2009 BY DART AEROSPACE LTD

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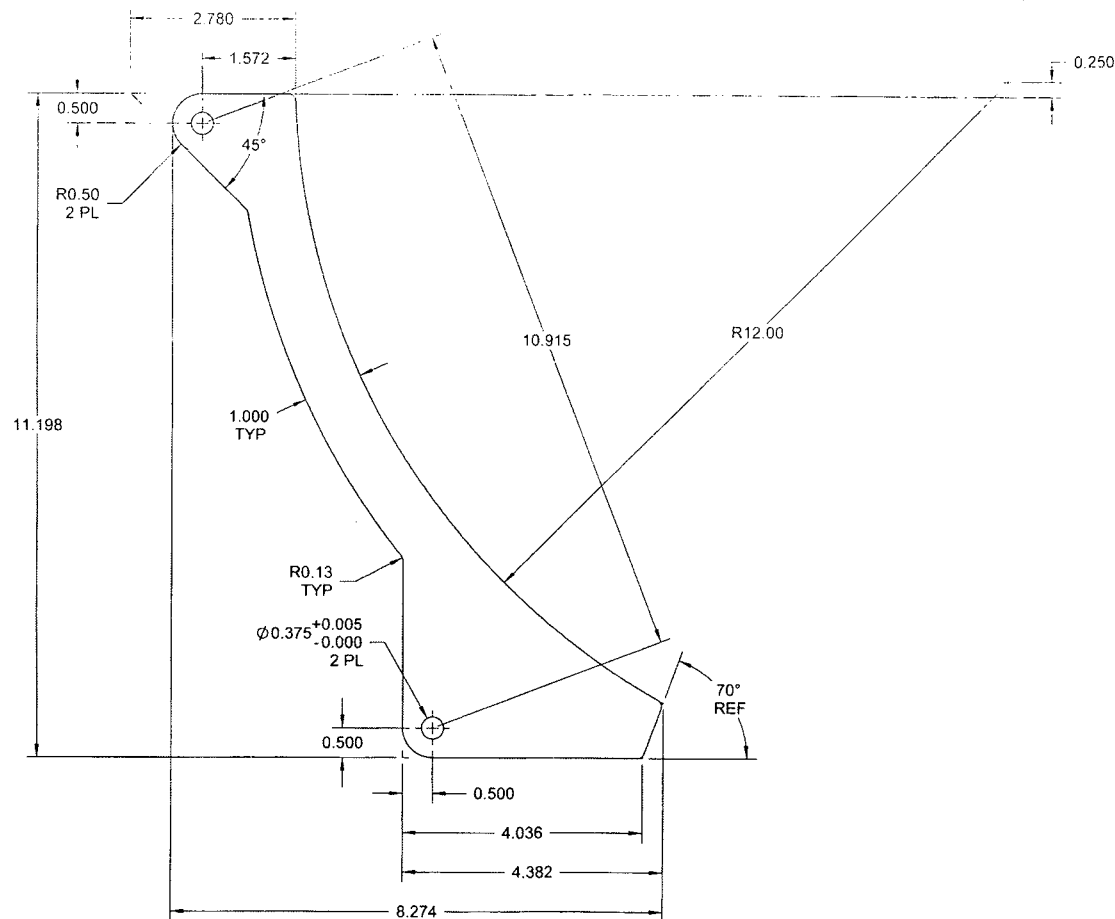
98367

D3929-1
SUPPORT GUSSET
2 PL

D3929-1
SUPPORT GUSSET
2 PL

0.25
2 PL, REF

D3907-1
BUSHING
2 PL

2 PL

2 PL

D3907-1
BUSHING
2 PL

0.25
2 PL, REF

D3929-1
SUPPORT GUSSET
REF

D3929-1
SUPPORT GUSSET
REF

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE 09.04.03		COPYRIGHT © 2009 BY DART AEROSPACE LTD	

94367

2.780

1.572

0.500

0.250

45°

R0.50
2 PL

10.915

R12.00

11.198

1.000
TYP

R0.13
TYP

Ø0.375 +0.005 -0.000
2 PL

70°
REF

0.500

0.500

4.036

4.382

8.274

D3929-1 SUPPORT GUSSET

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
   11 GAUGE (0.125 THICK)
   REF. DART SPEC. M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.72 lbs

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	